

Classifications

EN ISO 3581-A	AWS A5.4 / SFA-5.4
E 20 25 5 Cu N L R 3 2	E385-16 (mod.)

Characteristics and typical fields of application

UTP 1925 is a rutile-basic coated stick electrode for joining and surfacing on stainless steels and cast iron with increased corrosion resistance to reducing media.

The weld metal is rustproof, IK-resistant (wet corrosion up to 350 °C). It has good corrosion properties in reducing media, corresponding to steels of the same type.

Base materials

1.4500, 1.4505, 1.4506, 1.4539


Typical analysis

	C	Si	Mn	Cr	Ni	Mo	Cu
wt.-%	0.025	0.8	1.5	20.0	25.0	4.5	1.5

Mechanical properties of all-weld metal - typical values (min. values)

Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	Impact energy ISO-V KV J
MPa	MPa	%	20°C
400	580	30	70

Operating data

	Polarity	DC + / AC	Dimension mm	Current A
	Redrying	2 h / 120-200°C	2.5 × 300	60 - 80
			3.2 × 350	80 - 120
			4.0 × 400	100 - 160
			5.0 × 450	140 - 190

The welding area must be metallurgically bright and well degreased. Preheating and post heat treatment generally not required.

Approvals

TÜV (04186.)